

Work Order ID 60239

Tuesday, June 29, 2010 11:49:43 AM



Page 1

Item ID: D4091-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 6/29/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date:

10/6/29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4091

A

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 1.450" LONG

0.00

DJP 10/07/12

12 8

110

0.00



HAAS I

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA920 AND DWG

FOLIO REV: *AA*

DWG REV: *A*

0.00

MW 10/07/18

12 8

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

mc
10/07/18

12

0

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

mc
10/07/19

12

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

mc
10/07/19

12

0

W/O:		WORK ORDER CHANGES					
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Item Name: Mounting Lug				Stop	
Start Date: 6/29/2010	Start Qty: 12.00				
Required Date: 7/6/2010	Req'd Qty: 12.00				
Reference:					
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M114841</i> START 5:45 Memo <i>QOUT. 320°</i> FINISH 4:13.	0.00 0.00							
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location: <i>460</i> Memo	0.00 0.00							

=) *u* 16/07/20

12 10-7-19

X12

10-7-20 *(120)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4



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Process Plan:

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/07/21

ME

10-7-21

W/O:		WORK ORDER CHANGES						
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Picklist Print

Tuesday, June 29, 2010 11:49:47 AM

Page 1

Work Order ID: 60239



Parent Item: D4091-1



Parent Item Name: Mounting Lug


Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423  Lug Extrusion		Manufactured	No			100	f	425.4002	0.1251	1.580211			



Location

Loc Qty

Loc Code

MAT06

425.4001895

43722

180

45800

245.400189

1,5802(f) → DIA 10/27/12

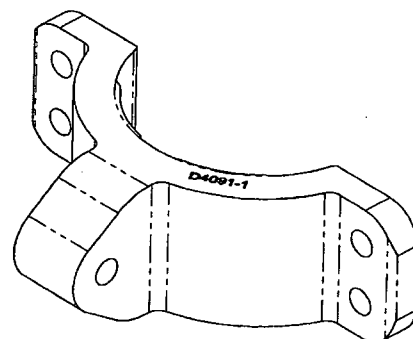
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D4091-1 MOUNTING LUG

SHOW ONLY
 RELEASED TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 60239
2810-629

RELEASED
 2010-04-28
W

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
 OF 0.015 \pm 0.005
- 7) WEIGHT: 0.31 lbs

A NEW ISSUE		CP 10.03.29	
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	CP		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.29		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D4091	SHEET 1 OF 2
TITLE	MOUNTING LUG	SCALE
		NTS

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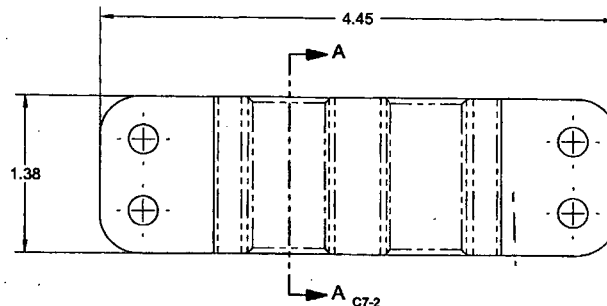
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R0.03-R0.07
TYP AROUND PAD

SECTION A-A C5-2



0.27
REF

0.293

Q
SYMM

R1.20

FILLET SHARP EDGES
PER SECTION
A-A

MACHINE TO
SIZE

D4091-1

6

MACHINE TO
SIZE

0.735
REF

0.375

3.700

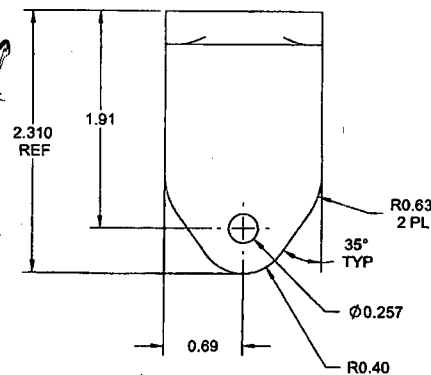
Ø0.257
4 PL

R0.34
TYP

Ø0.625

0.375

D4091-1 MOUNTING LUG



RELEASED
2010-04-20

DESIGN	OP	DART AEROSPACE LTD	
DRAWN	OP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4091	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	10.03.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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